May 17

Work Order ID 84274 *84274*

May-08-12 3:58:36 PM

Item ID: D4594-1 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Plate

Start Date: 08/05/2012 **Start Qty:** 1.00 2 *1*

Required Date: 22/05/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** MCJ **Date:** 12/05/08 **Tooling:** ______ **Date:** ______ **Run Start** *NR1* **Stop** *NR2*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4594	**Revision Nbr:** A					(4)			
100 *100* Waterjet FLOW CNC Waterjet 6061 .032	FLOW WATER JET **Memo** 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00 0.00			Recut	2	∅	B12-5-10	JM 12-5-14
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00			Recut	2	∅	B12-5-10	JM 12-5-14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** __________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Item ID:	D4594-1	**Accept**	*N900040100*
Revision ID:		**Setup**	**Start** *NS1*
Item Name:	Plate		**Stop** *NS2*
Start Date:	08/05/2012	**Start Qty:** 1.00	*1*
Required Date:	22/05/2012	**Req'd Qty:** 1.00	*1*
Reference:			

Cust Item ID:
Customer:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				(4)			WW 12-05-15
140 *140* Brake NC Brake NC	Bend as per dwg NC BRAKE **Memo**	0.00 0.00				(2)	4		8D 12/05/15
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 S 12/05/15				(2)	4		

PTO

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W/O: 84274	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4594-1 PAR #: ______ Fault Category: Small Fab. NCR: (Yes) No DQA: [signature] Date: 12/05/23

12-1438 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [signature] Date: 12/5/23

118.60 x 4 = 474.40

NCR:	WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
12/05/15	140	4 piece crack when forming. All in same location. R-C process	[signature] 12/05/14 Q52012	Scrap, destroy & replace with another batch no 120218 Qty x2 qty 4	[signature] 12/05/15	[signature] 12/05/15	[signature] Q52042 12/5/14	[signature] 12/5/14

NOTE: Date & initial all entries

Work Order ID 84274
May-08-12 3:58:36 PM

84274

Item ID:	D4594-1	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Plate	**Stop**	*NS2*
Start Date:	08/05/2012	**Start Qty:** 1.00	*1*
Required Date:	22/05/2012	**Req'd Qty:** 1.00	*1*
Reference:		**Cust Item ID:**	
		Customer:	

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				2	[illegible]	12515	
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat **Memo**	0.00 0.00				2	∅	[illegible] 12515.	
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: ST115 **Memo**	0.00 0.00				2		Suc 12/5/15	

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W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ______

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ______ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 84274

May-08-12 3:58:36 PM

84274

Item ID: D4594-1
Revision ID:
Item Name: Plate

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 08/05/2012 **Start Qty:** 1.00 *1*
Required Date: 22/05/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190*	QC21- Final Inspection - Work Order Release	0.00					12/5/16		
QC Quality Control	Memo	0.00							

MLJ 12/05/15

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

May-08-12 3:58:39 PM

Work Order ID: 84274 *84274*

Parent Item: D4594-1 *D4594-1*

Parent Item Name: Plate

Start Date: 08/05/2012 **Required Date:** 22/05/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP revA 12.01.23 new issue EC verified by:DD IPP REV:B
12.02.24 as per dwg reva DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	302.7160	0.155	0.163158	1	RB 12-5-10	

M6061T6S.032

6061-T6 Sheet 0.032"

**

Location		Loc Qty	Loc Code	
MAT021		302.716		
	118106	48.606		
	120218	33.77		
	120285	42.24		
	121099	178.1		121099

(4)

Recut: 120218 JM 12-5-14

Dart Aerospace Ltd

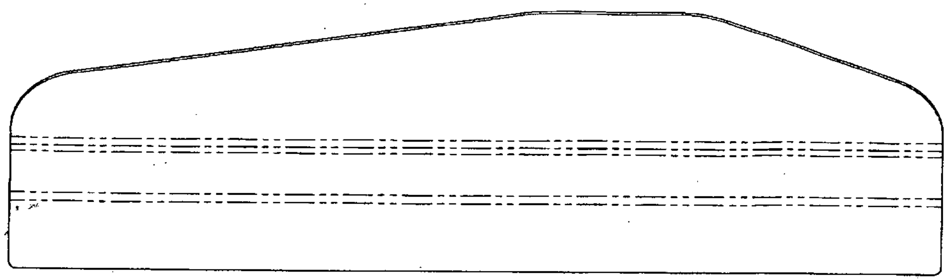
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

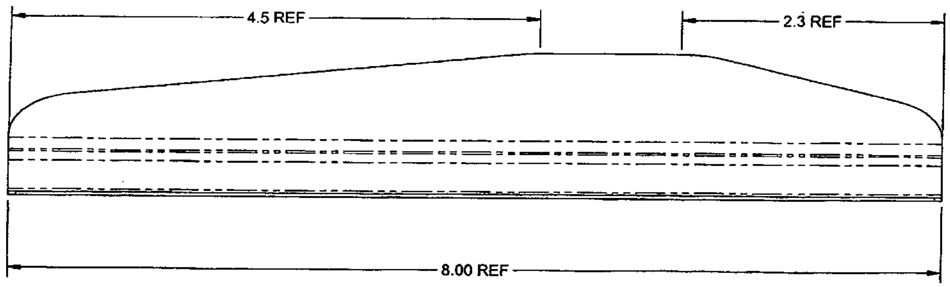
Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

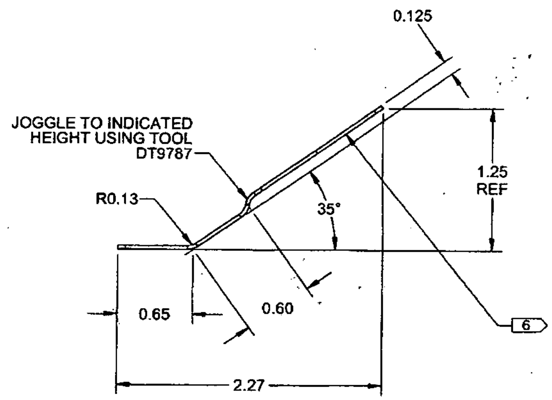
Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84274 MLJ
12/05/08

D4594-1 PLATE

RELEASED
2012 -02- 16

NOTES:
1) MATERIAL: MAKE FROM D4594-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4594-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	12.01.09

DESIGN	[signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	[signature]	
CHECKED	[signature]	DRAWING NO. D4594 — REV. A — SHEET 1 OF 2
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE: PLATE — SCALE: NTS
DE APPR.	[signature]	
DATE	12.01.09	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

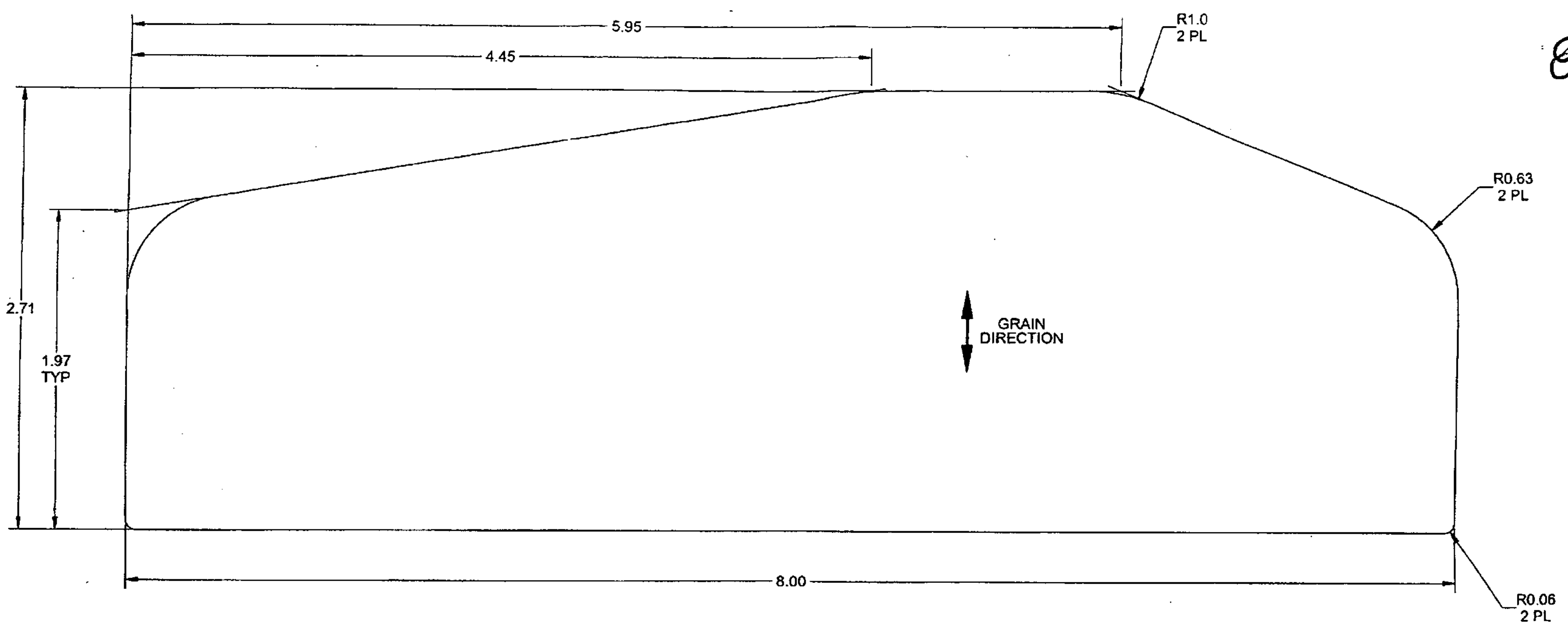
Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84274



D4594-1F PLATE

RELEASED 2012 -02- 16

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D4594	REV. A SHEET 2 OF 2
MFG. APPR.			
APPROVED		TITLE PLATE	SCALE NTS
DE APPR.			
DATE	12.01.09		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	84274
Description: D4594-1 PLATE	Part Number:	D4594-1
Inspection Dwg: D4594-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.71	+/- .030	2.708	✓		✓ BCL	
8.00	+/- .030	7.997	✓		✓	
4.45	+/- .030	4.45	✓		✓	
5.95	+/- .030	5.95	✓		✓	
.032	+/- .010	.037	✓		✓	
Recut						
2.71	+/- 0.030	2.713	✓		✓	HB-02
8.00	+/- 0.030	7.990	✓		✓	Produ J02
4.45	+/- 0.030	4.489	✓		✓	HB-02
5.95	+/- 0.030	5.945	✓		✓	HB-02
0.032	+/- 0.010	0.031	✓		✓	HB-02
	JM 12-5-14					

Measured by:	B	Audited by:	[signature]	Prototype Approval:	N/A
Date:	12-5-10	Date:	12-05-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	